

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011259**Date Inspected:** 05-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, M.Manikandan was present during the time noted above for observations relative to the work being performed.

**OBG # TRIAL ASSEMBLY YARD (5CE-6AE)**

This QA inspector participated in a joint survey of longitudinal diaphragm with ABF and ZPMC for below segment. Reports forwarded to team leader for further action

**5CE-6AE**

This QA Inspector randomly observed the following work in progress:

**OBG # TRIAL ASSEMBLY YARD (6AW-6BW)**

Heat straightening of longitudinal diaphragm located on 6AW-6BW Crossbeam. ZPMC CWI is identified as Li Yang. Heat straightening was been performed against HSR1 (B)-7992 Rev.0 dated 11th Dec. 2009. The weld designations reviewed are as follows:

SEG029B-007/008

SEG029C-038/039

SEG027D-035/038

SEG027F-035/038

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LD009A-01 to 010

LD010A-01 to 010

OBG # TRIAL ASSEMBLY YARD (6BW-6CW)

SMAW Process:

Welding of weld joint – 001 located on PCMK OBW6A, Edge panel transverse splice weld. Welder is identified as 068917. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-B-U2-FCM-1.

OBG # TRIAL ASSEMBLY YARD (5AW-5BW)

FCAW Process:

Welding of weld joint – 005 located on PCMK CA015, Side panel corner assembly. Welder is identified as 049769. ZPMC CWI is identified as Li Yang. Welding was been performed against welding repair report B-WR8556 Rev.0. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-2G (2F)-FCM-Repair.

Y locations are identified as 130 and 200mm

OBG # TRIAL ASSEMBLY YARD (6CW)

FCAW Process:

Welding of weld joint – 047 located on PCMK SSD25-PP45, FL3 of 6CW. Welder is identified as 051246. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231T.

OBG # TRIAL ASSEMBLY YARD (6BW-6CW)

FCAW Process:

Welding of weld joint – 020 located on PCMK BP087-001, CJP joining T-Rib of 6BW and 6CW. Welder is identified as 053609. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U2-F.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

No Relevant Conversation.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or

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remedial efforts please contact , who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Manikandan,Murugan	Quality Assurance Inspector
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<b>Reviewed By:</b>	Miller,Mark	QA Reviewer
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